

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015033**Date Inspected:** 21-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena, Jesse Cayabyab			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	SAS OBG	

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified 3W/4W-E, 1W/2W-D/S and the following observations were made:

1W/2W-D/S**D/S#6**

Upon the arrival of the QA Inspector at the above identified location it was observed the ABF welder James Zhen was performing shielded metal arc welding (SMAW) repairs. The QA Inspector randomly observed the ABF welder was continuing the SMAW repairs started previously. The QA Inspector noted the repair appeared to be approximately 60% complete upon the arrival of QA Inspector in the AM. The QA Inspector randomly observed the SMAW parameters and they were 1/8" E7010 low hydrogen electrodes with 126 Amps. The QA Inspector noted the SMAW parameters appeared to be consistent with the ABF approved WPS identified as ABF-WPS-D1. 5-1001 repair. The QA Inspector randomly observed the ABF welder complete the SMAW repair on this date. The QA Inspector noted no grinding was performed on this date. The QA Inspector randomly observed and noted all of the welding and repairs at the longitudinal stiffeners appeared to be completed. The QA Inspector noted additional grinding tasks will need to be completed.

3W/4W-E

The QA Inspector randomly observed the ABF welder Rory Hogan and Jeremy Doleman had previously started the induction heating blankets on the outside of OBG to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker

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and noted the minimum required preheat had been achieved. The QA Inspector observed the ABF welder to be utilizing flux cored arc welding (FCAW) with the semi-automated bugo track system for the above identified weld joint. The QA Inspector randomly observed the Smith Emery (SE) QC Inspector identified as Tony Sherwood set the FCAW machine to the parameters of the approved WPS identified as ABF-WPS-D1.5-3042A The QA Inspector randomly observed the FCAW parameters were 247 Amps, 23.9 Volts and a travel speed of 320mm/min. The QA Inspector noted the ABF welder spent the remainder of the QA Inspectors shift performing the FCAW fill passes of the back weld. The QA Inspector randomly and periodically observed the welding at the above identified location. It was noted by the QA Inspector the ABF welder did not complete the FCAW on the QA Inspectors shift.

The QA Inspector spent the remainder of the shift researching and updating the ABF production welding tracking chart and logbook.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
